

Date: Wednesday, 23/07/2008 3:06:08 PM
 User: Linda Lacelle

Process Sheet

Spent wlo
8/08/07/25

Customer : CU-DAR001 Dart Helicopters Services
 Job Number : 40734 -2
 Estimate Number : 13298
 P.O. Number :
 This Issue : 23/07/2008 S.O. No. :
 Prsht Rev. : NC
 First Issue : / / Type : SMALL / MED FAB
 Previous Run : 39036
 Written By :
 Checked & Approved By :
 Comment : Est Rev:A 08-05-01 new issue DD verified by:EC
 Est Rev:B 08-07-22 revB as per dwg DD verified by:EC

Drawing Name : SUPPORTING PLATE
 Part Number : D37811
 Drawing Number : D3781 PRELIM
 Project Number : N/A
 Drawing Revision : PRELIM
 Material :
 Due Date : 30/07/2008 Qty: 10 Um: Each

Additional Product

PRELIMINARY ISSUE

POSITIVE
RECALL

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M6061T6S080 6061-T6 .080 Sheet



Comment: Qty.: 0.2896 sf(s)/Unit Total: 2.8959 sf(s)

6061-T6 .080 Sheet

batch: 107460 IB 8-7-23

2.0 WATER JET FLOW WATER JET



Comment: FLOW WATER JET

1-Cut as per Dwg D3781-1

Dwg Rev: PRE-L

Prog Rev: PRE-L

*****grain direction along 3.61" *****

2- Deburr if necessary

IB 8-7-24

(14)

3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

IB 8-7-24

4.0 QC8 SECOND CHECK



Comment: SECOND CHECK

5 08/07/24 (14)

5.0 BRAKE NC NC BRAKE



Comment: NC BRAKE

Bend as per Dwg D3781

5 09/01/14 (9)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3781-1 PAR #: _____ Fault Category: _____ NCR: Yes ☐ No ☒ DQA: D Date: 09/03/14
 QA: N/C Closed: _____ Date: _____

NCR: <u>40734</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
<u>09/01/14</u>	<u>5</u>	<u>1 piece crack broke</u>	<u>JB</u> <u>09/01/14</u>	<u>Scrap & destroy</u>	<u>SB</u> <u>09/01/14</u>	<u>JB</u> <u>09/01/14</u>	<u>JB</u> <u>09/01/14</u>	<u>JB</u> <u>09/01/14</u>

NOTE: Date & initial all entries

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SUPPORTING PLATE

Job Number: 40734

Part Number: D37811

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1
1-counter sink holes as per dwg D3781

EP 09/01/14 (8)

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

SB 09-01-14 (8)

8.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1
Chemical Conversion Coat as per QSI 005 4.1

M-1 09/01/14

9.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

FX 09/01/14 (8)

10.0

MS20426AD34

RIVET



Comment: Qty.: 10.0000 Each(s)/Unit Total : 100.0000 Each(s)
RIVET
batch: *M 104374*

SB 09/01/14 (8)

11.0

MS21075L3

Nutplate



Comment: Qty.: 5.0000 Each(s)/Unit Total : 50.0000 Each(s)
Nutplate
batch: *M 109371*

SB 09/01/14 (8)

12.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1
1- assemble nut plate as per dwg D3781

EP 09/01/14 (8)

13.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

SB 09-01-14 (8)

**ENGINEERING
APPROVAL**

SB 09-01-14

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3781-1 PAR #: _____ Fault Category: _____ NCR: Yes ☐ No ☒ DQA: AD Date: 09/03/04
 QA: N/C Closed: _____ Date: _____

NCR: <u>40734</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
	<u>7</u>	<u>one over bent</u>	<u>[Signature]</u> <u>09/03/04</u>	<u>scrap & destroy</u>	<u>[Signature]</u> <u>09/03/04</u>	<u>[Signature]</u> <u>09/03/04</u>	<u>[Signature]</u> <u>09/03/04</u>	<u>[Signature]</u> <u>09/03/04</u>

NOTE: Date & initial all entries

Date: Wednesday, 23/07/2008 3:06:08 PM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SUPPORTING PLATE

Job Number: 40734

Part Number: D37811

Job Number:



Seq. #:

Machine Or Operation:

Description :

14.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

handz/chunks > send to Aerolex

15.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/02/12

Job Completion



U 09.01.30

POSITIVE RECALL

EFFECTIVE

RELEASED

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POSITIVE RECALL

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CSK $\phi 0.188$
TYP

1.88

C

D3781-1 SUPPORTING PLATE
MAKE FROM D3781-1F

B

R0.25
TYP

9.500

5.500

1.500

2.61

2.859

A

7.50

D3781-1F FLAT PATTERN**D3781-1 NOTES:**

- 1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET, 0.080 THICK
PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027
(REF. DART SPEC. M6061T6S.080)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.28 lbs

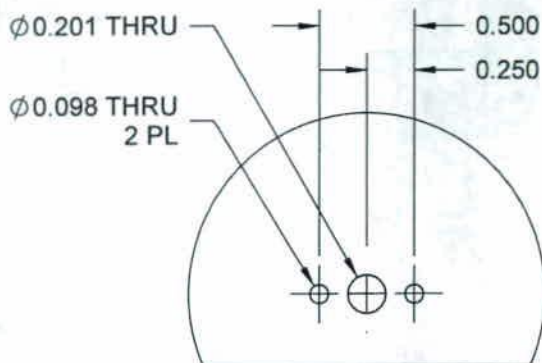
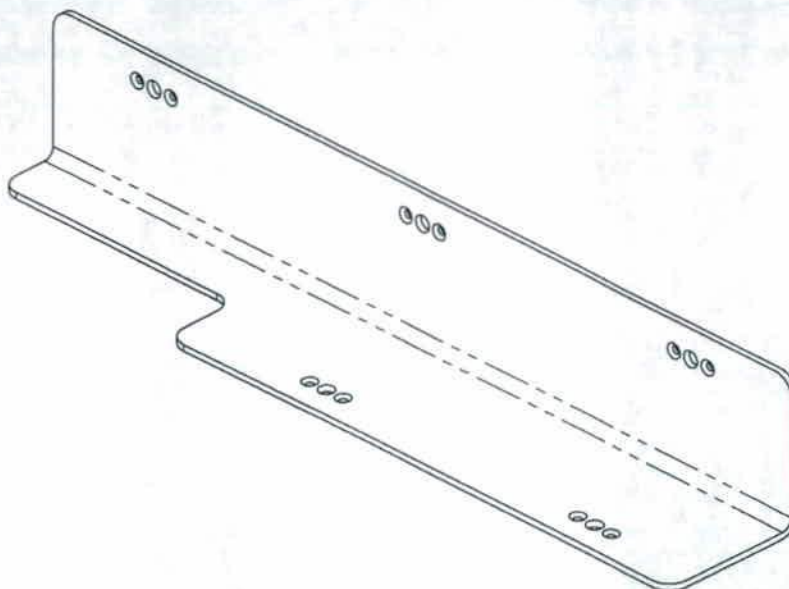
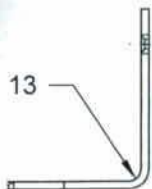
w/o
40734

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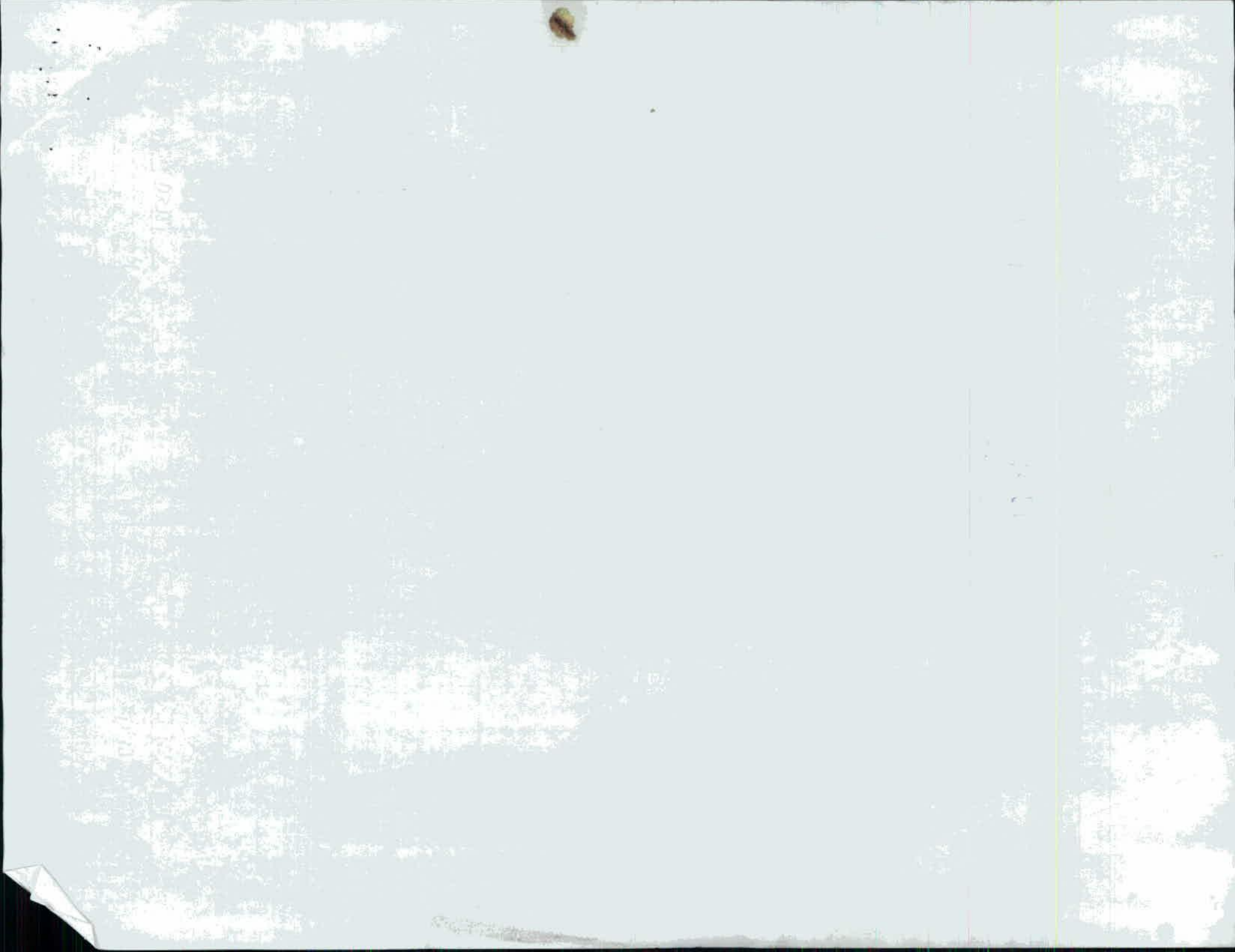


DETAIL B
SCALE 2X, 5 PL

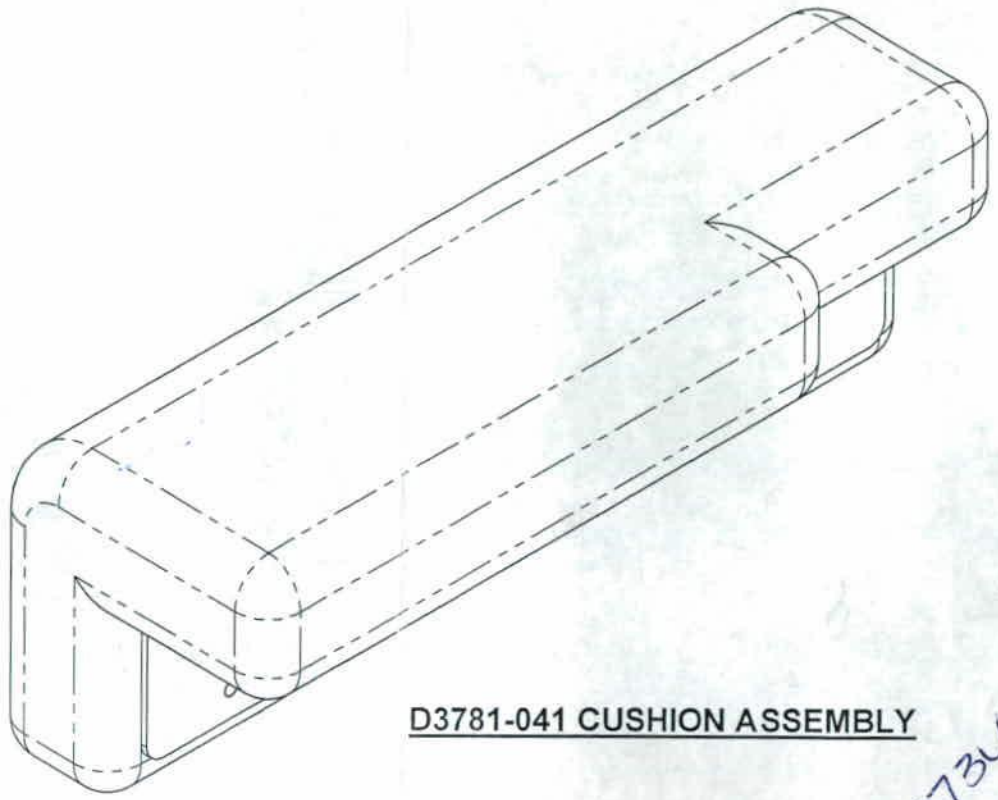
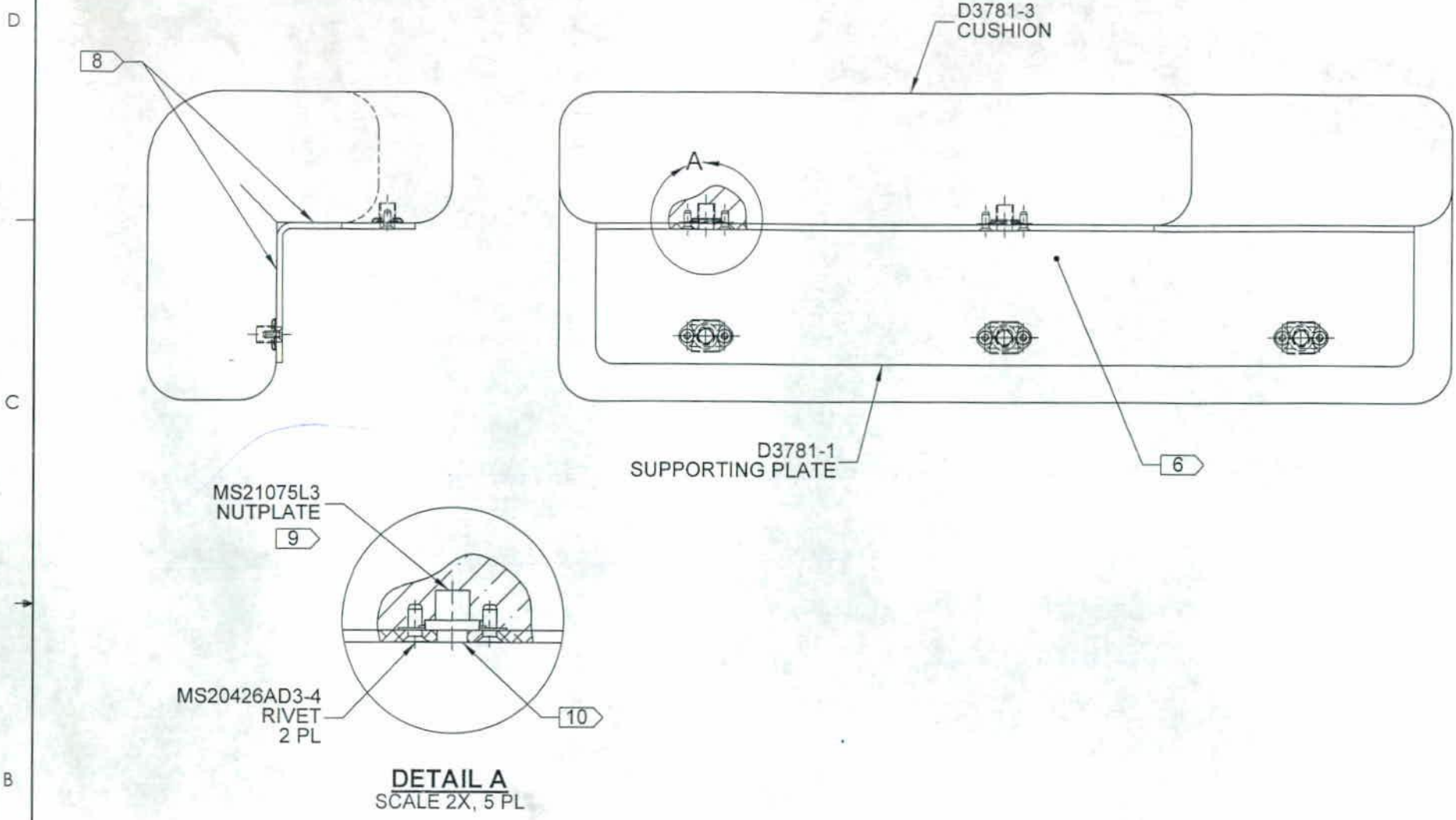
PRELIMINARY ISSUE

08.07.16

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3781	SHEET 2 OF 3
APPROVED		TITLE	SCALE
DE APPR.		CUSHION ASSEMBLY	NTS
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QTY -041	P/N	DESCRIPTION
X	D3781-041	CUSHION ASSEMBLY
1	D3781-1	SUPPORTING PLATE
1	D3781-3	CUSHION
10	MS20426AD3-4	RIVET
5	MS21075L3	NUT PLATE (OR MS21075-3)
A/R	SY-111	SURREY SILVER SUNSET UPHOLSTERY FABRIC
A/R	1300	3M SCOTCH-GRIP ADHESIVE

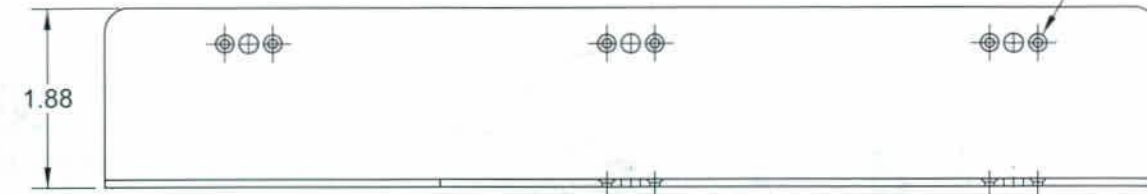
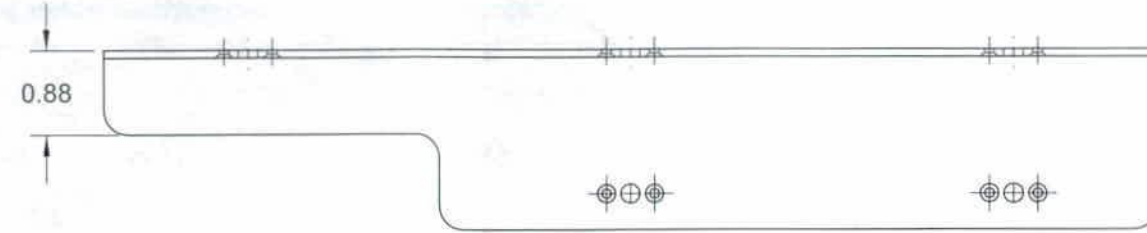


D3781-041 CUSHION ASSEMBLY

- D3781-041 NOTES:**
- 1) MATERIAL: COVER D3781-1/-3 ASSEMBLY WITH SURREY SILVER SUNSET UPHOLSTERY FABRIC P/N SY-111. BOND FABRIC USING 3M 1300 ADHESIVE (0.002" TO 0.010" THICK) IN ACCORDANCE WITH MANUFACTURER'S INSTRUCTIONS. THREAD: MIL-VT-295 TYPE II CLASS A, GREY NYLON THREAD, 4-6 STITCHES PER INCH, USE 1/2" MIN BACKSTITCH, NO LOOSE THREADS
 - 2) FINISH: N/A
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3781-041" USING FINE POINT PERMANENT INK MARKER
 - 7) WEIGHT: 1.00 lbs
 - 8) BOND D3781-3 CUSHION TO D3781-1 SUPPORTING PLATE USING 3M 1300 ADHESIVE (0.002" TO 0.010" THICK) IN ACCORDANCE WITH MANUFACTURER'S INSTRUCTIONS
 - 9) IT IS ACCEPTABLE TO RELIEVE D3781-3 CUSHION WHERE THE NUTPLATES ARE LOCATED TO ENSURE PROPER CONTACT WITH D3781-1 SUPPORTING PLATE
 - 10) HOLES MUST BE FREE OF ADHESIVE AND FABRIC

B	REDESIGNED; ADDED DETAIL A (ZN B7-1)	MB	08.07.15
A	NEW ISSUE	MB	08.04.29
REV.	DESCRIPTION	BY	DATE
DESIGN		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN			
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3781	SHEET 1 OF 3
APPROVED		TITLE	SCALE
DE APPR.		CUSHION ASSEMBLY	NTS
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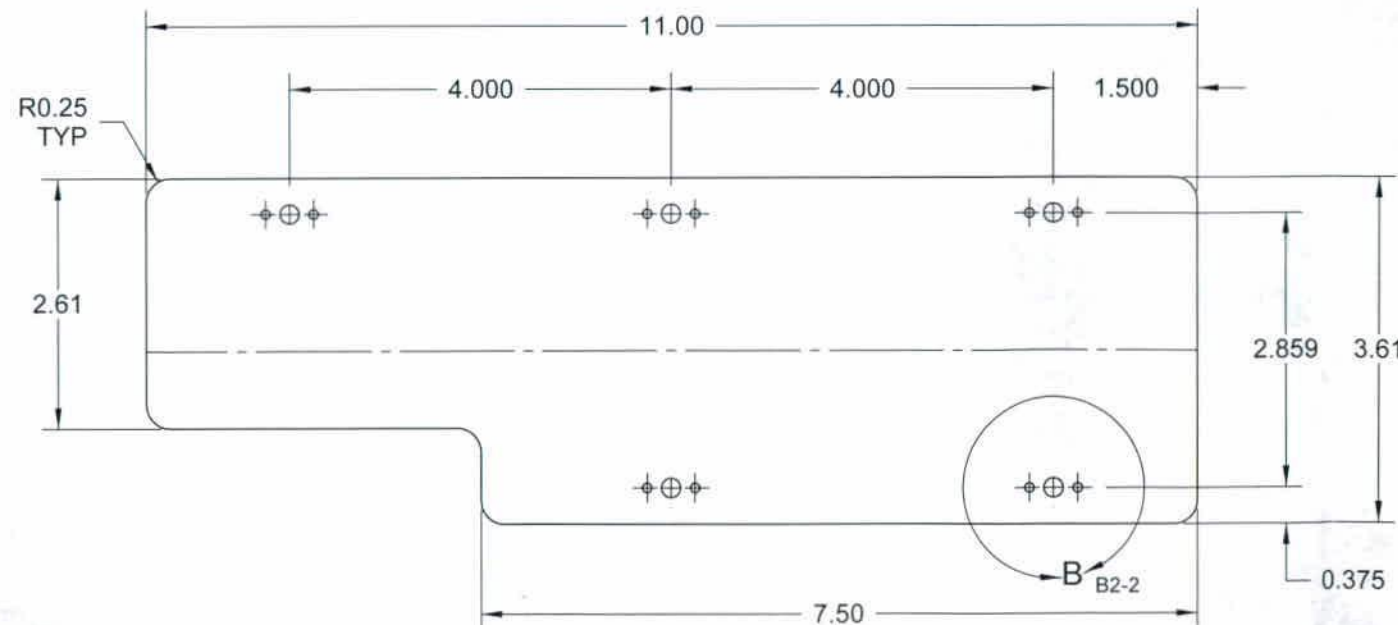




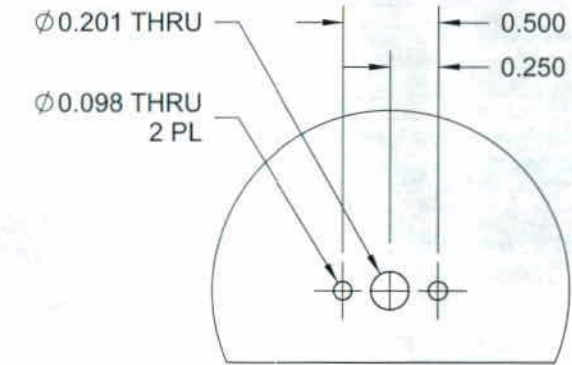
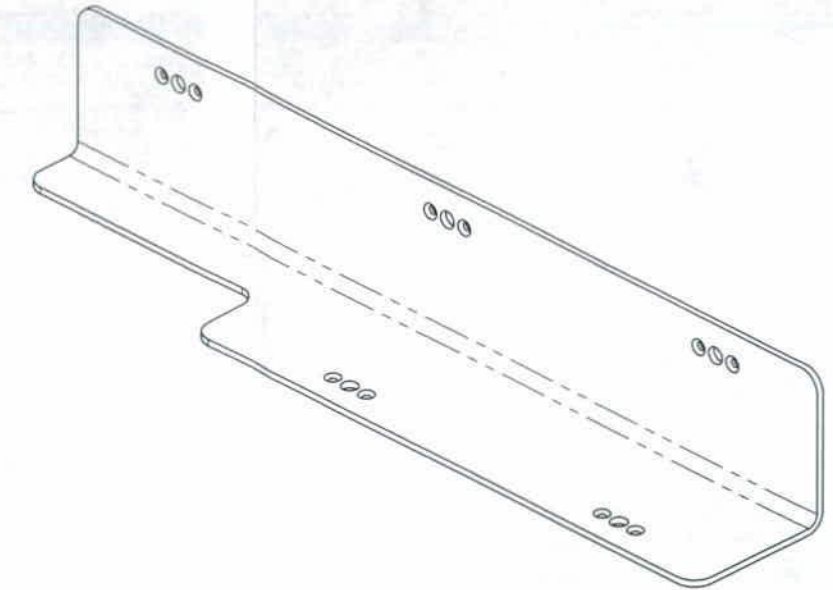
CSK $\varnothing 0.188 \times 100^\circ$
TYP

R0.13

D3781-1 SUPPORTING PLATE
MAKE FROM D3781-1F



D3781-1F FLAT PATTERN



DETAIL B
SCALE 2X, 5 PL A5-2

PRELIMINARY ISSUE
A09.9.1 REF. BCW #093028

40734

D3781-1 NOTES:

- 1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET, 0.080 THICK PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027 (REF. DART SPEC. M6061T6S.080)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.28 lbs

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D3781	SHEET 2 OF 3
APPROVED		TITLE	SCALE
DE APPR.		CUSHION ASSEMBLY	NTS
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ВЕРИМЫЙ
1827



- Unit 24, 2333 - 18 Ave NE, Calgary AB T2E 8T6 - Phone: (403) 295 - 8770 - Fax: (403) 313 - 0793 -

CERTIFICATION OF CONFORMANCE

Customer Purchase Order:

7965

Our Work Order:

5743

THIS IS TO CERTIFY THAT THE FOLLOWING MATERIALS HAVE BEEN USED IN THE WORK ORDER STATED ABOVE:

FOAM - HR150

MATERIAL - SURREY SILVER SUNSET

HAS BEEN FABRICATED TO ESTABLISHED SPECIFICATION TO CONFIRM WITH FAR 25.853 (A)

SOLD TO:

DART AEROSPACE LTD., 1270 ABERDEEN STREET, HAWKESBURY, ON K6A 1K7

AUTHORIZED REPRESENTATIVE

A large, stylized handwritten signature in black ink, written over a horizontal line.



#24, 2333 - 18 Ave NE
Calgary, AB T2E 8T6
Phone: (403) 295-8770
Fax: (403) 313 0793

Packing Slip

Date	Packing Slip#
1/15/2009	5743

Ship To

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, Ontario K6A 1K7
Canada

Invoice To

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, Ontario K6A 1K7
Canada

Customer Phone	Customer Fax
613.632.5200	613.632.1053
Ship Via	Courier Acct No.
FedEx	15179324-0

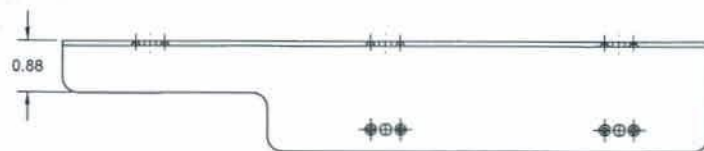
Ship Date	P.O. No.
1/23/2009	7965

Description	Part Number	Qty
C JSHION ASSEMBLY * SURREYSILVER SUNSET VINYL PN: SY-111 GST On Sales	D3781041	9

Thank you for doing business with Aerotex Interiors!

www.aerotexinteriors.com

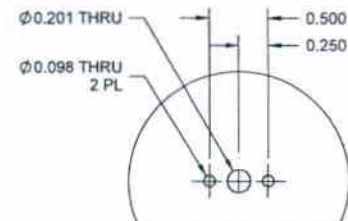
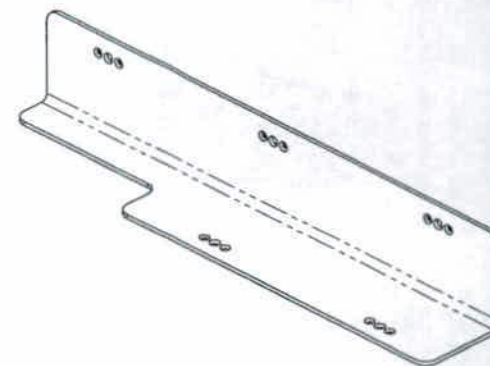
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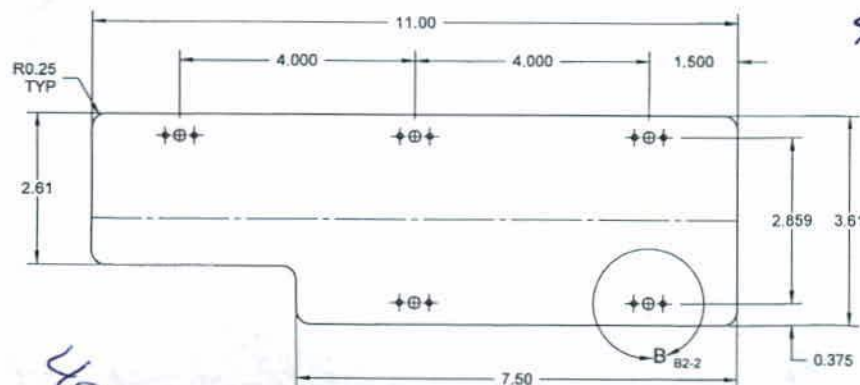


D3781-1 SUPPORTING PLATE
MAKE FROM D3781-1F



DETAIL B A5-2
SCALE 2X, 5 PL

RELEASED
9/12/05



D3781-1F FLAT PATTERN

D3781-1 NOTES:

- 1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET, 0.080 THICK
PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027
(REF. DART SPEC. M6061T6S.080)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.28 lbs

DESIGN	1	DART AEROSPACE LTD	
DRAWN	1	HAWKESBURY, ONTARIO, CANADA	
CHECKED	CH	DRAWING NO.	REV. C
MFG. APPR.	1	D3781	SHEET 2 OF 3
APPROVED	1	TITLE	SCALE
DE APPR.	1	CUSHION ASSEMBLY	NTS
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